
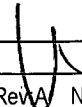



Date: Wednesday, 1/23/2008 11:31:50 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TOP PANNEL ASS'Y	
Job Number : 36912		
Estimate Number : 13067		
P.O. Number :	Part Number : D3650041	
This Issue : 1/23/2008 S.O. No. :	Drawing Number : D3650 REV.B U/R	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B U/R	
Previous Run : 35715	Material :	
Written By : 	Due Date : 2/29/2008	Qty: 2 Um: Each
Checked & Approved By : 		
Comment : Est Rev: A New Issue 07-11-12 EC verified by: DD Est Rev: B Ecn 1113P 08-01-22 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 pick kit

2.0	D36501	AFT PANEL
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 AFT PANEL
 batch B36941

3.0	D36503	CENTER PANEL
-----	--------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 CENTER PANEL
 batch B36942

4.0	D36505	CENTER PANEL
-----	--------	--------------




Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 CENTER PANEL
 batch B36943

5.0	AN3C3A	Bolt
-----	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
 Bolt
 batch N1106993

B 08.03.13 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: A Date: 08/03/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:31:50 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANNEL ASS'Y

Job Number: 36912

Part Number: D3650041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C10

WASHER



Comment: Qty.: 8.0000 EACH(s)/Unit Total : 16.0000 EACH(s)

WASHER

batch: 1106302

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1-Assemble as per dwg D3650

2- Seal all mating surfaces and all gaps using Proseal 700 fire wall sealant

as per dwg D3650

Batch: 11062901

08.03.13

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PH 08.03.13
ENGINEERING
APPROVAL

08/03/14 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: PPA 3803

08/03/14 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.03.18
08/03/14

Job Completion



POSITIVE RECALL

EFFECTIVE 08.01.31

AUTH 11

RELEASED 12

DATE 08.03.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

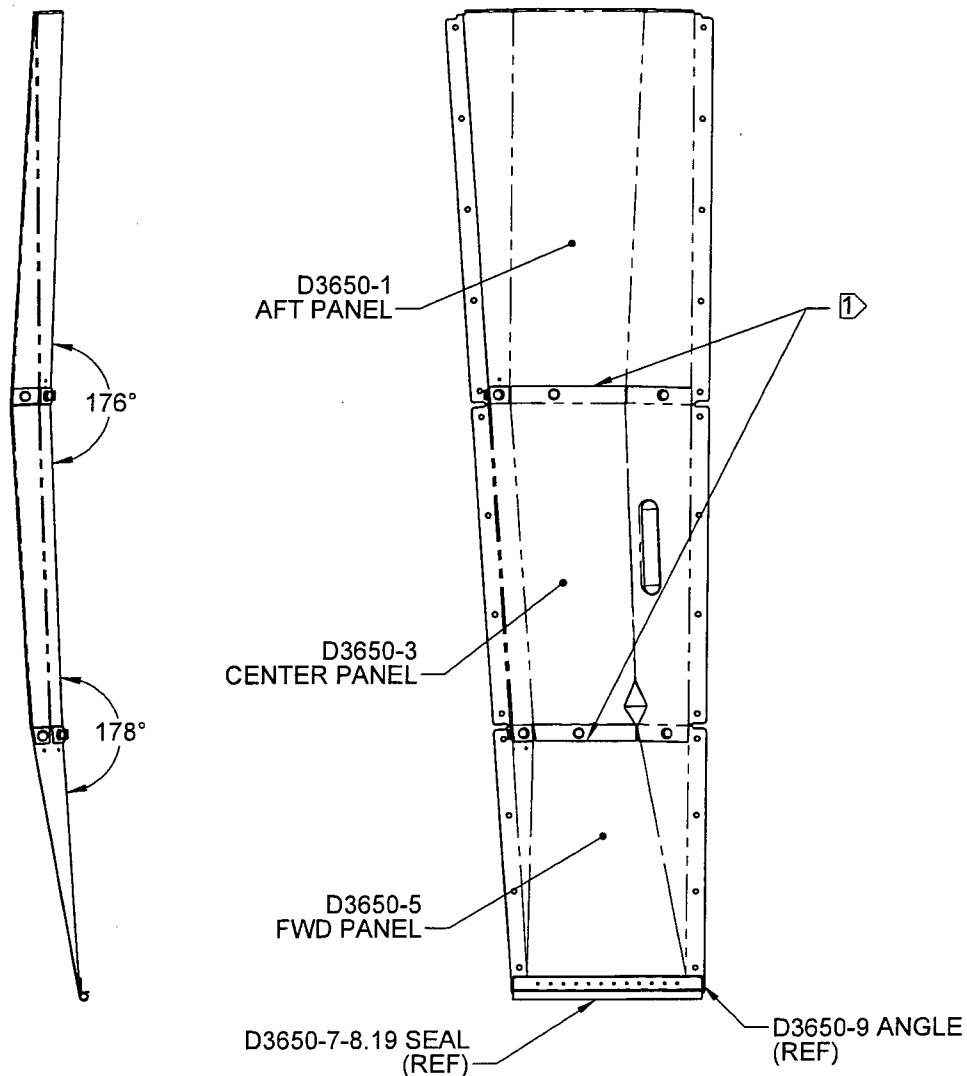
1

D

C

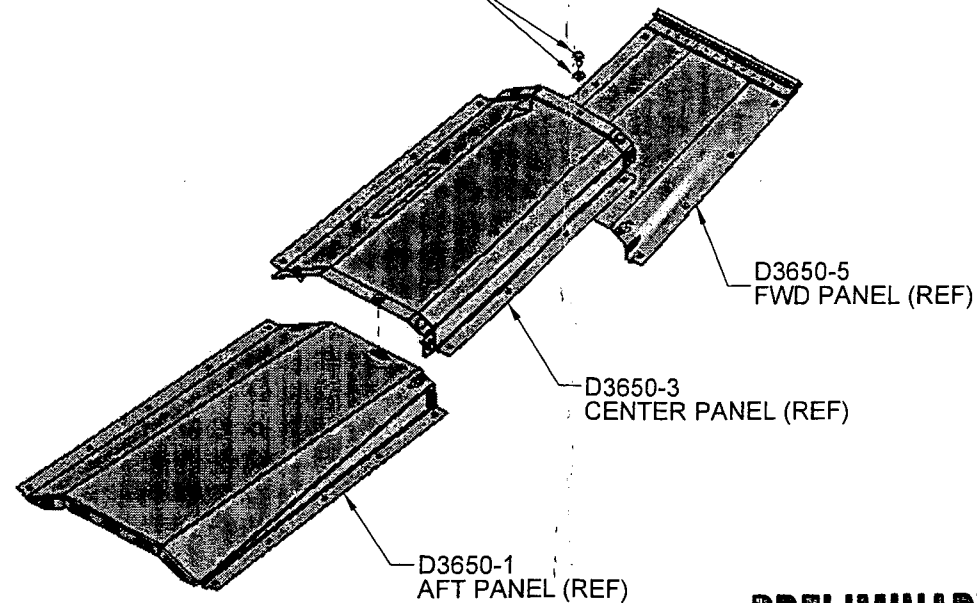
B

A

**D3650-041 TUNNEL TOP PANEL ASSEMBLY****NOTES:**

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

AN3C-3A BOLT (1)
AN960C10 WASHER (1)
(8 PLACES)

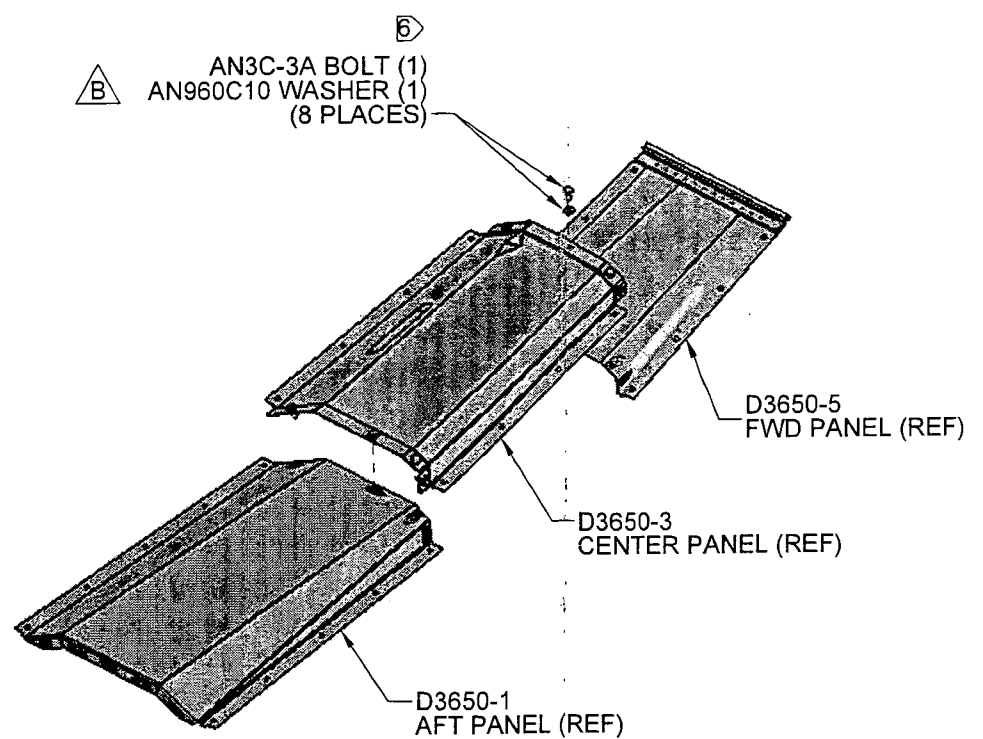
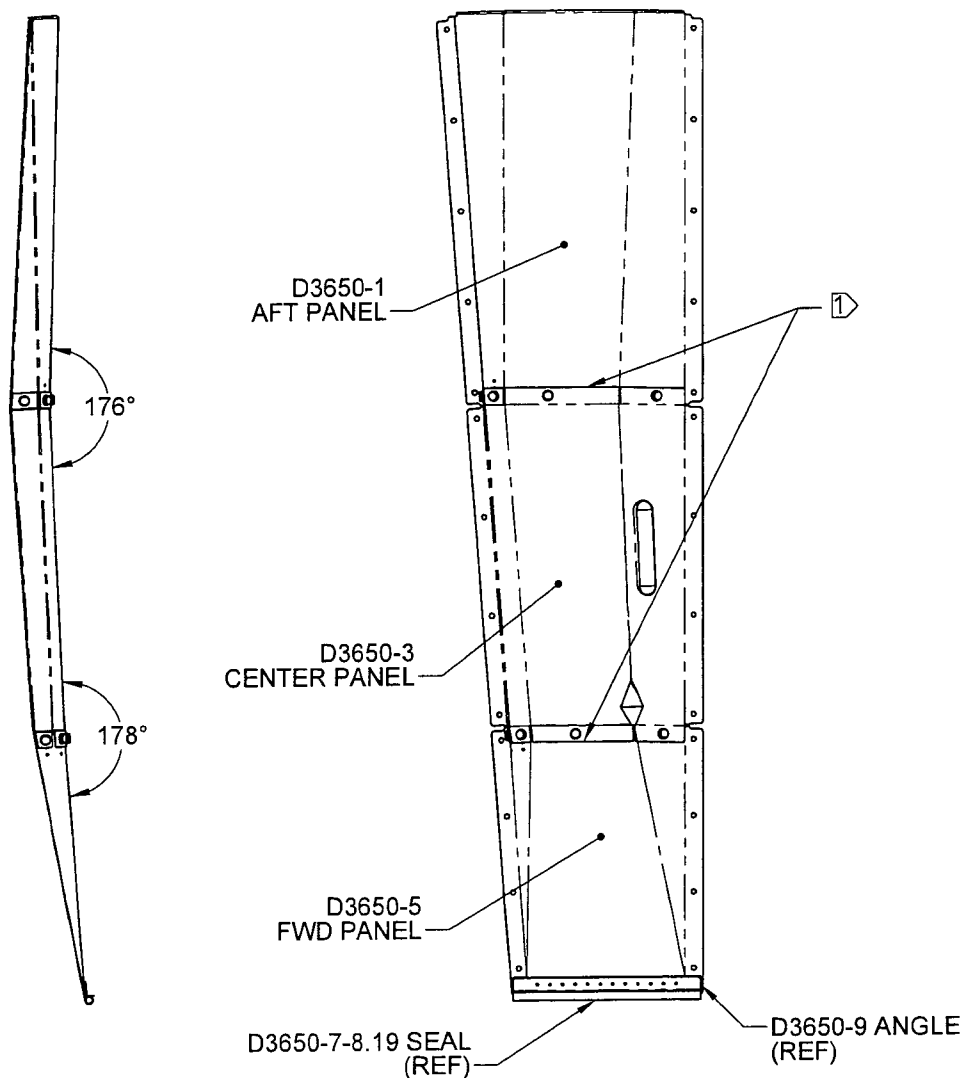
**PRELIMINARY ISSUE**

UE 08.01.18

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS OF D3650-11/-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	UE	DRAWING NO.	REV. B
MFG. APPR.	DA	D3650	SHEET 1 OF 9
APPROVED	MA	TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:8
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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D3650-041 TUNNEL TOP PANEL ASSEMBLY

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